Date:

Friday, 11/24/2006 8:54:59 AM

User:

Chantal Lavoie

## **Process Sheet**

Customer

Job Number **Estimate Number** 

: CU-DAR001 Dart Helicopters Services

: 10103

P.O. Number

Prsht Rev.

F rst Issue

:NIA

: 11/24/2006 This Issue

S.O. No. : N/A

: SMALL /MED FAB

: 26938 **Previous Run** 

Written By

Checked & Approved By Comment

Added Steps 5-7

KJ/JLM

**Drawing Name** 

: 8" MIRROR

**Part Number** 

: D2011103

**Drawing Number** 

. D2011 REV. F : N/A

**Project Number** 

**Drawing Revision** 

Material **Due Date**  : HIA : 12/1/2006

Qty:

50 Um:

Each

**Additional Product** 

Job Number: .



Seq. #:

Machine Or Operation:

Description:

PURCHASING

1.0

PG

Comment: PURCHASING

Issue P/0: <u>2555</u>

Velvac Mirror P/N: 708441 Possible supplier: UAP/NAPA Material release note required

2.0

708441

c Locelli 24

MIRROR 8"

Comment: Qty.:

1.0000 Each(s)/Unit Total:

50.0000 Each(s)

Mirror 8"

3.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment: PACKAGING RESOURCE #1** 

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

QC6 4.0

Comment: DIMENSIONAL CHECK

5.0

D30153

Lock Nut

Comment: Qty.:

1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Locknut

Pick:

Pick:

Qty Part Number Description Batch

Look put 63870 6

rospace L	td						
		٧	VORK ORDER CHANGES	3			
STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		2 -	5)				
•	PAR #:	Fault Ca	tegory: N	NCR: Yes	No DQA: 1	Date: <	56/12/0
						Date: _	
	V	VORK OR	DER NON-CONFORMAN	CE (NCR	2)		
CTED	Description of NC		Corrective Action Section B		- Verification	Approval	Approval
Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	•		349				
			<b>4</b> 10				
	1						
	STEP	:PAR #:V	STEP PROCEDURE CH  PROCEDURE CH  PAR #: Fault Ca  WORK OR  STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE  :PAR #:Fault Category:N  WORK ORDER NON-CONFORMANG  STEP Description of NC Section A Corrective Action Section E Initial Chief Eng Chief	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes( QA: N  WORK ORDER NON-CONFORMANCE (NCR  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty  :PAR #:Fault Category:NCR: Yes No DQA: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Chief Eng	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng Prod Mgr

NOTE: Date & initial all entries

Date: Friday, 11/24/2006 8:54:59 AM Chantal Lavoie User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 8" MIRROR Job Number: 29690 Part Number: D2011103 Job Number: Seq. #: **Machine Or Operation:** Description: AN960JD516 6.0 Washer 1.0000 Each(s)/Unit Total: 50.0000 Each(s) Comment: Qty.: Washer Pick: **Qty Part Number** Description Batch M 100568 1 AN960JD516 Washer SMALL & MEDIUM FAB RESOURCE 1 7.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Discard Hardware & Install new hardware loosely white 2- Inject 3ml of Black Sikaflex adhesive per hole. Qty Part Number Description m102107 A/R Sikaflex-291 Expiry date QC5 INSPECT WORK TO CURRENT STEP 8.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1.

Identify and Stock

Location:

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

10.0



06/2-05



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
			<u> </u>		<u> </u>							
Part No	.•	PAR #· Fault Category:	NCR: Ves	No DO	Δ.	Date:						

Part No	:	PAR #:	NC	R: Yes No	DQA:	Date: _			
						QA: N/C	Closed:	_ Date: _	
NCR:		\	WORK ORDI	ER NON-CONFO	RMANCI	E (NCR)			
		Description of NC		Corrective Action	Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial	Action Description		Sign &	Section C	Chief Eng	OC Inspector

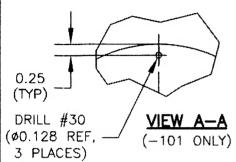
		Description of NC	Corrective Action Section B		,,	Verification	Annecusi	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
							i	

NOTE: Date & initial all entries

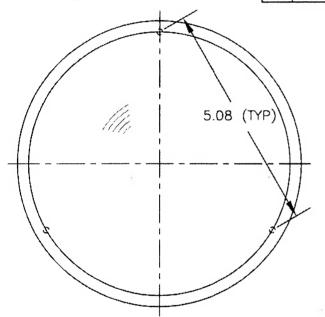




DESIGN	DRAWN BY	DART AEROSF HAWKESBURY, ONTAF	
CHECKED	APPROVED	DRAWING NO.	REV. F
#	- H	D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2
		T .	



04.0	9.10	MIRROR ASSEMBLY 1:2
	90.03.31	NEW ISSUE
Α	90.06.15	DWG No. WAS DSP1011, ADDED -103
В	98.04.09	SIKAFLEX 241 ADDED
С	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD
Ε	01.05.08	NEW 8" MIRROR
F	04.09.10	ADD HOLES FOR SEALANT ON -101



DRILL AND SEAL PER NOTE 1 FOR -101 MIRRORS ONLY (TYP 3 PLACES)

MIRROR ASSEMBLY (SUPPLIED)

## REFERENCE ONLY

D3014-1 (OR D3015-3) LOCKNUT (1) AN960JD416L (OR AN960JD516) WASHER (1). INSTALL LOOSE. DISCARD ATTACHMENT HARDWARE INCLUDED WITH PURCHASE OF MIRROR

PLUG DRAIN HOLE (IF PRESENT) WITH SIKAFLEX-241/-291 SEALANT AS REQUIRED.



QTY -101	QTY -103	Part Number	Description
Х		D2011-101	MIRROR ASSEMBLY 6"
	Х	D2011-103 > C	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

## NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WKESBURY AUTO PARTS INC 5580GST#: 4 MAIN STREET WEST WKESBURY, ONT. K6A 2J2 L:632-8575 FAX: 632-1539

861597896RT0001 EXC#:SU 6259 EXP:03/12/31

DANGEROUS GOODS PERMIT

EXPIRY DATE:

**EMERGENCY TELEPHONE NUMBER 24 HOURS** CANUTEC 613-996-6666

ACCT #		SOLD	at .		DAT	ΓE	TIN	1E	STO	RE#	EMP	# INVOICE N
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